



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D2893-1

Job Sheet R201484



Part No: D2893-1

Job Qty: 5 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/4/19

Job Tracking No: ECN19-829

Due Date: 10/14/19

Created By: Linda Lacelle

Type: Rework

Description:

Note: DWG D2893 REV D IPP: C 02.11.26 Reformat; Added P/O KJ IPP D 06.04.19 removed alodine EC IPP Rev:E
Added priming as per Rev B 07-04-30 JLM IPP F 08.03.19 Re-format EC verified by: DD IPP Rev:G 08-05-15
add QC14 DD verified by:EC IPP Rev:H 11.08.04 as per dwg rev.C ver:ECDWG /IPP Rev. I 19.10.01 New
issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Rework - 1 - Startup	5 pcs	10/14/19		2.00	9.80	HAAS - 1		19-10-25
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	5 pcs	10/14/19		0.00	0.00	QC 2 - 1		19-10-25
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S226430



Part: D2893-1

Job No: R201484

Serial No/Batch: S226430

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 10/25/19

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				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
120	QC 8	5 pcs	10/14/19	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
130	Crosstubes - 2 - B4B	5 pcs	10/14/19	0.00 0.83	Crosstubes - 1 - B4B
					Crosstubes - 2 - B4B
					Crosstubes - 3 - B4B
					Crosstubes - 4 - B4B
140	QC 3	5 pcs	10/14/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19

on 19/10/28

DAS
41 OCT 29 2019
9-89

DAS
81
9-89

NOV 06 2019

170 Packaging 3-1 - Stock - B4B 5 pcs	10/14/19	0.00 0.00	QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	DAS
			Packaging 3 - 22 - B4B	41 NOV 07 2019
			Packaging 3 - 23 - B4B	9-89
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
180 QC 21 - SA 5 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21	
			QC 21 - SA - 70	DAS
			QC 21 - SA - 53	21
			Broussard	9-89

NOV 07 2019

Part Op 100 - 1-Machine as per Folio FA081
 Descriptions: 130 - (Crosstubes) Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 5306999 exp 8/21
 140 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: LG050) LOCATION : LG050
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2893-1	Support	5 pcs (1 ea)	100-Rework - 1 - Startup	5201476

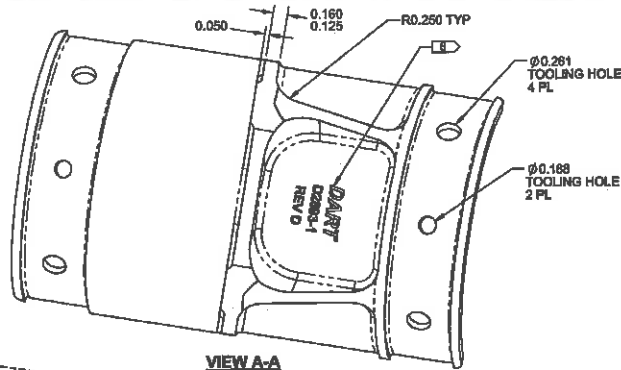
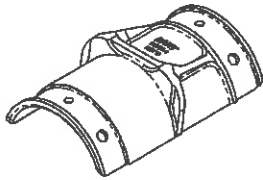
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Rework - 1 - Startup	D2893-1	5	17	0

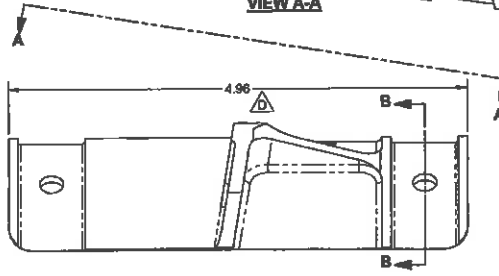
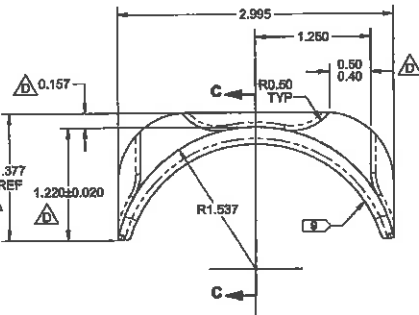
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	2.985Inches + 0.020 - 0.000	3.005 2.985		
2	2.750 Support	0.440Inches + 0.020 - 0.000	0.460 0.440		
3	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
4	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
5	2.750 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
6	2.750 Support	0.125Inches + 0.035 - 0.000	0.160 0.125		
7	2.750 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
8	2.750 Support	1.360Inches + 0.040 - 0.000	1.400 1.360		
9	2.750 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
10	2.750 Support	1.190Inches + 0.040 - 0.000	1.230 1.190		
11	2.750 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
12	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
13	2.750 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
14	2.750 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
15	2.750 Support	84.390Inches + 6.000 - 0.000	90.390 84.390		
16	2.750 Support	0.261Inches + 0.005 - 0.000	0.266 0.261		
17	2.750 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		

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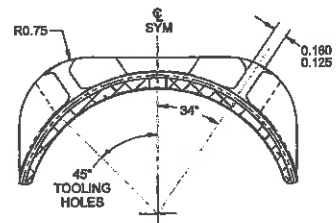
also
R201484



VIEW A-A



D2893-1 SUPPORT, 212 FWD



SECTION B-B

- NOTES:
- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H926 CONDITION
MIN UTS = 170 KSI (88 HRc)
(REF DART SPEC. D8104)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART LOGO, PART NUMBER, AND REVISION IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP WITH MIN TOOL RAD OF R0.010 PER DART QSI 044 6.3
 - 7) WEIGHT: 0.73 lbs
 - 8) MACHINE INNER SURFACE PROFILE AND NON-DIMENSIONS FEATURES PER D2893-1-REV.D STEP
 - 9) FOR THE ENTIRE INNER CONCAVE SURFACE: ABRASE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT).
APPLY 0.050" THICK LAYER OF 3M SCOTCH-WEELD 2216 B/A ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

RELEASED
2019-09-30
SCN 19-1001

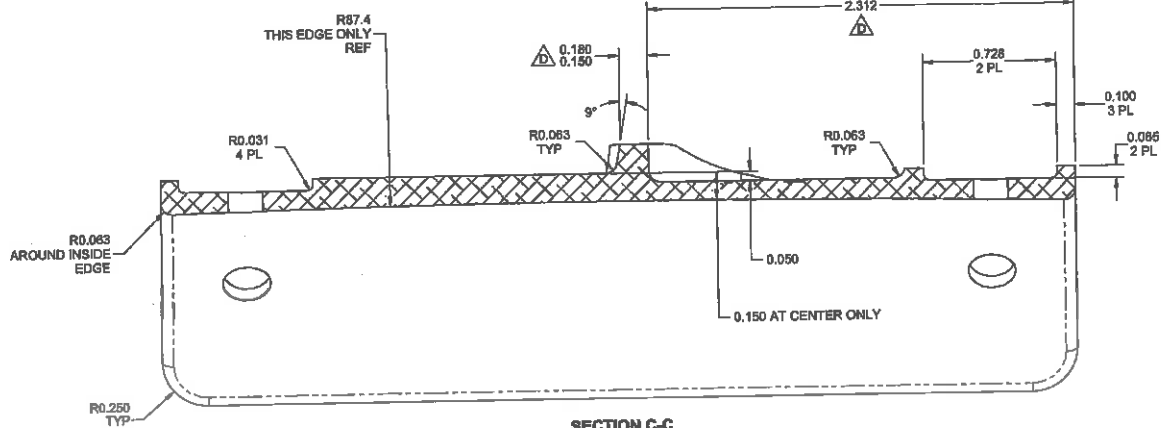
DESIGN	CP	19.07.12
DRAWN	CP	11.07.16
CHECKED	MM	07.05.13
APPROVED	JFB	01.01.10
DATE	19.07.12	

REV.	DESCRIPTION	BY	DATE
D	REDRAW IN 9W, CHG INNER SURFACE PROFILE. ADD REV TO TEXT, 3M 2216 NOW 0.030 THICK, DMS AS MFD	CP	19.07.12
C	RMV FINISH, ADD 3M 2216, ADD H926 MATL. OPTION	CP	11.07.16
B	UPDATE DMS AS MFG, PRIME INSIDE	PH	07.05.13
A	NEW ISSUE	CP	01.01.10

DESIGN	CP	19.07.12
DRAWN	CP	11.07.16
CHECKED	MM	07.05.13
APPROVED	JFB	01.01.10
DATE	19.07.12	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

D2893
SUPPORT, 212 FWD
REV. D
SHEET 1 OF 2
SCALE
NTS



SECTION C-C

RELEASED
2019-09-30

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2893 TITLE SUPPORT, 212 FWD Copyright © 2012 by DART Aerospace Ltd. All rights reserved. No part of this drawing may be reproduced without the written permission of DART Aerospace Ltd.	REV. D
DRAWN	CP		SHEET 2 OF 2
CHECKED	MW		SCALE
MFG. APPR.	JFS		NTS
APPROVED	NO		
DE APPR.	CP		
DATE	19.07.12		

